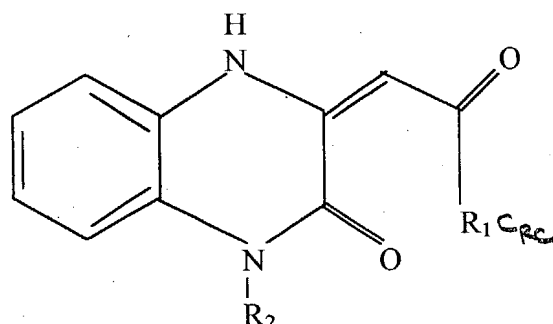


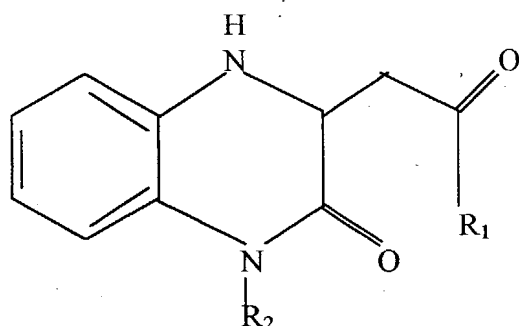
We claim:

1. A process for the preparation of hydrogen peroxide comprising (a) hydrogenating a compound of formula I

**FORMULA I**

wherein R_1 is selected from CH_3 , C_2H_5 and C_6H_5 and R_2 is selected from the group consisting of H and CH_3 provided that when R_1 is C_2H_5 or C_6H_5 , R_2 is H, in the presence of a palladium catalyst to obtain a compound of formula II; and

- (b) contacting said compound of formula II

**FORMULA II**

so obtained wherein R_1 is selected from CH_3 , C_2H_5 and C_6H_5 and R_2 is selected from the group consisting of H and CH_3 provided that when R_1 is C_2H_5 or C_6H_5 , R_2 is H, with an oxidant selected from the group consisting of molecular oxygen, air and a mixture thereof, in a biphasic system selected from ethylacetate - water and chloroform-water systems to obtain hydrogen peroxide.

2. A process as claimed in claim 1 wherein the compound of formula I is hydrogenated in the presence of an organic solvent selected from methanol and ethyl alcohol.
3. A process as claimed in claim 1 wherein the palladium catalyst is selected from Pd(10%)/carbon and Pd(5%)/carbon.
4. A process as claimed in claim 1 wherein the compound of formula II is contacted with oxidant in the presence of an organic solvent selected from the group consisting of benzene, ethyl acetate, chloroform, dichloromethane and tert.butyl alcohol.

5. A process as claimed in claim 1 wherein the compound of formula I is selected from the group consisting of 3 - 2 - (oxopropyl) - 2(1H) - quinoxalinone, 3 - 2 - (oxobutyl) - 2(1H) - quinoxalinone and 3 - 2 - (oxophenyl) - 2(1H) - quinoxalinone to obtain 3 - 2 - (oxopropyl) - 1,2,3,4 - tetrahydro - 2 - quinoxalinone, 3 - 2 - (oxobutyl) - 1,2,3,4 - tetrahydro - 2 - quinoxalinone and 3 - 2 - (oxophenyl) - 1,2,3,4 - tetrahydro - 2 - quinoxalinone respectively of formula II.
6. A process as claimed in claim 1 wherein the compound of formula II is contacted with oxidant in the presence of a mineral acid.
7. A process as claimed in claim 6 wherein said mineral acid comprises dilute sulphuric acid.
8. A process as claimed in claim 1 wherein the reaction is carried out at ambient temperature.
9. A process as claimed in claim 1 wherein compound of formula II is prepared from compound of formula I in the presence of Pd (10%) - carbon - H₂ (30 - 40 psig) or Pd (5%) - carbon - H₂ (30 - 40 psig).
10. A process as claimed in claim 1 wherein the hydrogenation pressure is in the range of 10 - 100 psig.
11. A process as claimed in claim 10 wherein the hydrogenation pressure is in the range of 20 - 40psig.
12. A process as claimed in claim 1 wherein the product is obtained in the form of an aqueous solution by removal of coloring materials from the water layer using activated carbon.